

# Work Order ID 79079

**\*79079\***

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Item ID: D3562-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Assembly, LH  
 Start Date: 19/01/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 02/02/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3562	Rev E

100	Large Fab	0.00							
<b>*100*</b>									
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding								

110	QC6- Inspect dimensions to drawing	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

120	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*120*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

*Handwritten notes and stamps:*  
 (x4)  $\phi$   
 Ae 12/02/01  
 - Cpl 12.02.01  
 4x  $\phi$   
 (x4)  $\phi$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> Large Fab	Large Fab	0.00				4	0		
Large Fab	Memo 1-Weld end caps as per Dwg d3562 & QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod <u>119185</u> 2-Grind end cap welds flush as per Dwg D3562	0.00							
170 <b>*170*</b> QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
180 <b>*180*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

*12.02.27*

*5/12/02/27*

*8/2/02/27*

*(+4)*  
*44*

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				4	0	②	DP/m/12/02/28.
200 <b>*200*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 10:10 OVEN TEMPERATURE: 3200 F- FINISH TIME: 10:40	0.00  0.00							4X/m/12/02/28
210 <b>*210*</b> HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch  Memo M120 125	0.00  0.00							12-2-28

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC3- Inspect Part Finish	0.00							
<b>*220*</b>									
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location: <b>G.A</b>	0.00							
<b>*230*</b>									
Packaging	Memo <b>W/O</b>	0.00							
Packaging	<b>79085</b>								
240	QC21- Final Inspection - Work Order Release	0.00							
<b>*240*</b>									
QC	Memo	0.00							
Quality Control									

**MLJ 12/02/29**  
**(4)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 79079

\*79079\*

Parent Item: D3562-041

\*D3562-041\*

Parent Item Name: Step Assembly, LH

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM  
 IPP rev B ECN 987 07.10.09 EC verified by: DD  
 IPP Rev:C ECN1048 07-12-18 DD verified by:ec  
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	54.3700	1	4			

\*D2622-120C\*

Step Extrusion

\*\*

Ac 12/02/01

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA013	38	
75781	38	

D2734

Manufactured No

140

Each

118.0000

2

8

\*D2734\*

Step End Plate

\*\*

12.02.25

Location	Loc Qty	Loc Code
WA	118	
76985	118	

D3560-041

Manufactured No

140

Each

1.0000

1

4

\*D3560-041\*

Arm Weldment

\*\*

12.02.24

Location	Loc Qty	Loc Code
WA013	1	
74803	1	

B79076

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Work Order ID: 79079

\*79079\*

Parent Item: D3562-041

\*D3562-041\*

Parent Item Name: Step Assembly, LH

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3560-043

Manufactured

No

140

Each

0.0000

1 4

\*D3560-043\*

Arm Weldment

MS20600-AD4W5

Purchased

No

160

Each

687.0000

32 128

\*MS20600-AD4W5\*

Blind Rivet

\*\*

\*\*

Location

Loc Qty

Loc Code

ST321 B120570 681

114382 173

117505 82

118384 226

120142 200

WA018 B120594 6

111477 6

107

21

12.02.24  
12.02.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

D3562-1,  
MAKE FROM  
EXTRUSION D2622

2  
APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

D3560-043 ARM WELDMENT

D3560-041 ARM WELDMENT

D3560-042 ARM WELDMENT

D3560-044 ARM WELDMENT

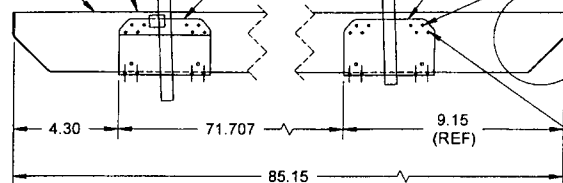
D3562-1,  
MAKE FROM  
EXTRUSION D2622

2  
APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

TRANSFER DRILL #30  
DEBURR & TOUCH UP HOLES  
WITH CHEMICAL CONVERSION  
COAT BEFORE RIVETING  
(32 PLACES PER STEP)

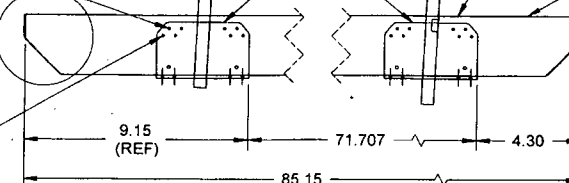
REFER TO STEP  
END DETAIL

INSTALL MS20600AD4W5 RIVET  
(32 PLACES PER STEP)



MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

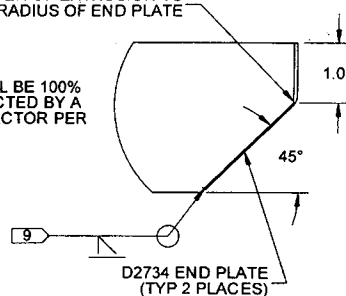


MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100%  
VISUALLY INSPECTED BY A  
QUALIFIED INSPECTOR PER  
DART QSI 004



TYPICAL STEP END DETAIL  
SCALE 1:2

### D3562-041 LH STEP ASSEMBLY

### D3562-042 RH STEP ASSEMBLY

#### NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION  
PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR  
GREY SANDTEX (4.3.5.6) OR  
BLACK SANDTEX (4.3.5.7) OR  
GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN  
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH  
MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

REV.	DESCRIPTION	BY	DATE
E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	64		
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.		D3562	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSEMBLY	1.5
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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